

Work Order ID 60574

Wednesday, July 14, 2010 9:56:49 AM



Page 1

Item ID: D3143-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clevis

Start Date: 7/14/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: *ML* Date: 10-7-14 Tooling: Date:

QC: Date: SPC (Y/N): Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3143 | Rev B | | | | | | | | |
| 100 | DOOSAN LATHE | 0.00 | | | | | | | |
| | | | | | | | | | |
| Doosan | Memo | 0.00 | | | | | | | |
| Doosan Lathe | 1-Turn as per Dwg D3143 and Folio FA948 | | | | | | | | |
| | Folio Rev: <u>N/A</u> | | | | | | | | |
| | Dwg Rev: <u>B</u> | | | | | | | | |
| | 2-Deburr | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

SL 10/08/04

SL 10/08/04

ML 10-8-4

(H)

(A)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 60574

Wednesday, July 14, 2010 9:56:49 AM



Page 2

Item ID: D3143-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clevis

Start Date: 7/14/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject Insp.
Number Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

10/8/05 (4)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/08/05**MF**10-8-05*

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 14, 2010 9:56:54 AM

Page 1

Work Order ID: 60574



Parent Item: D3143-1



Parent Item Name: Clevis

Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.07.14 new issue DD verf:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M303R0.500 | | Purchased | No | | | 100 | f | 38.0000 | 0.135 | 0.568421 | | | |



303 Round Bar 0.500"



| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT | 34.8 | |
| 114482 | 10.8 | |
| 114852 | 24 | |
| MAT028 | 3.2 | |
| 112567 | 3.2 | |

6 SL 10/08/09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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


Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

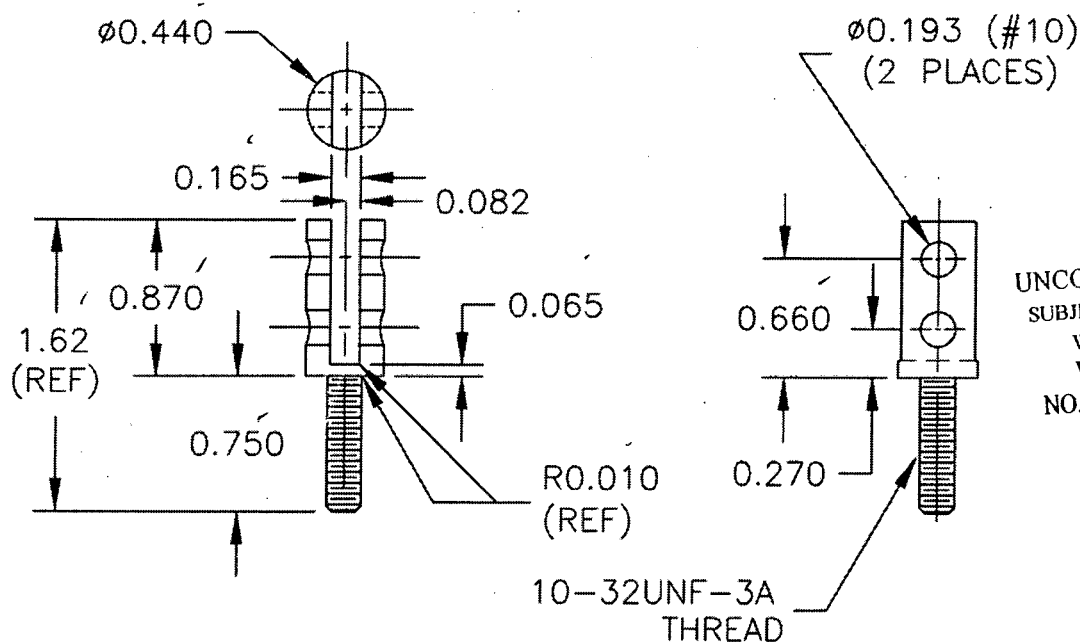
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NOTE: Date & initial all entries



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|------------------|---|----------|---|---|------------------------|
| DESIGN |  | DRAWN BY |  | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | APPROVED |  | DRAWING NO. D3143 | REV. B SHEET 1 OF 2 |
| DATE 04.10.18 | | | | TITLE CLEVIS | SCALE 1:1 |
| A | 02.04.19 | | | NEW ISSUE | |
| B | 04.10.18 | | | UPDATE NOTES | |

RELEASED
04.11.23 *[Signature]*



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *60574*

BL10-7-14

D3143-1 CLEVIS

D3143-1 NOTES

- 1) MATERIAL: ANNEALED AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 5) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-113
- 6) IDENTIFY WITH PART P/N USING FINE POINT PERMANENT INK MARKER

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| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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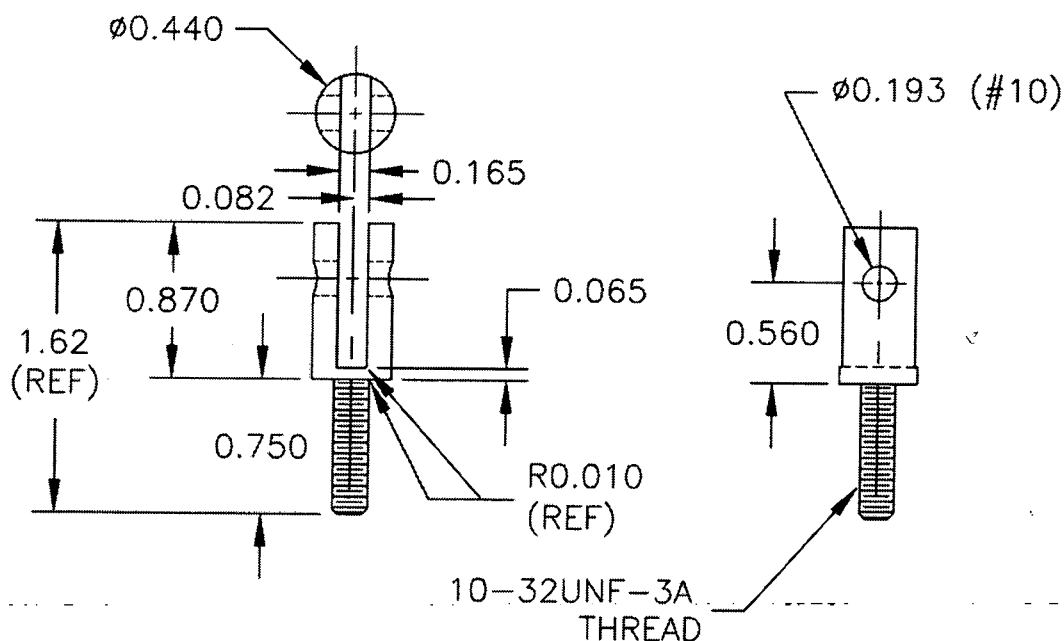
NOTE: Date & initial all entries



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|------------------|---------------|---|------------------------|
| DESIGN # | DRAWN BY # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3143 | REV. A SHEET 2 OF 2 |
| DATE 04.10.18 | | TITLE CLEVIS | SCALE 1:1 |

RELEASED
04.11.23

W/O 60574



D3143-3 CLEVIS

D3143-3 NOTES

- 1) MATERIAL: ANNEALED AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 5) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-179
- 6) IDENTIFY WITH PART P/N USING FINE POINT PERMANENT INK MARKER

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| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries